

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012334**Date Inspected:** 21-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Liu Hua Lie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment 9EE**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062761 perform Flux Cored Arc Welding (FCAW) welding on Suspender Bracket, weld joint identified as SB008-046-026 & 032. ZPMC QC is identified as Mr. Liu Hua Lie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 062761 perform Flux Cored Arc Welding (FCAW) welding on Suspender Bracket, weld joint identified as SB008-040-026 & 032. ZPMC QC is identified as Mr. Liu Hua Lie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132

This QA inspector observed ZPMC qualified welding personnel identified as 062761 perform Flux Cored Arc Welding (FCAW) welding on Suspender Bracket, weld joint identified as SB008-036-026 & 032. ZPMC QC is identified as Mr. Liu Hua Lie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132; see the attached photo.

Magnetic Particle Testing (MT)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector performed Visual Testing (VT) on OBG Segment 9EE and VT indications are confirmed by Magnetic Particle Testing (MT) on area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The indications are clearly marked on the material near the weld for future repair. The members are identified as OBG Segment 9EE. The weld designations reviewed are as follows:

OBG Segment 9EE-PP85 East side

1. FB016-038-004
2. FB003-134-004
3. FB010-023-002

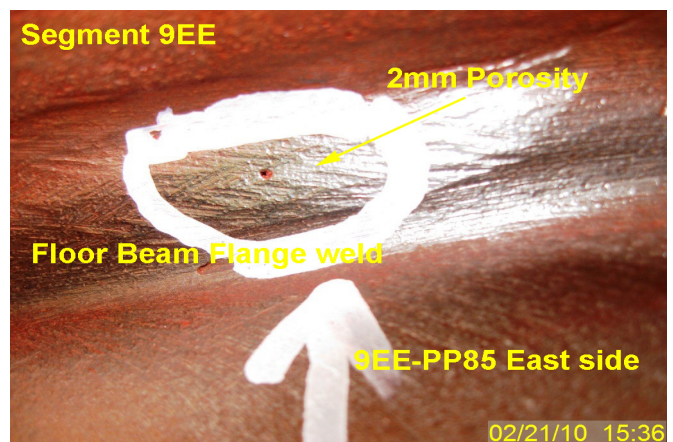
OBG Segment 9EE-PP84 East side

1. FB003-154-004
2. FB010-024-002

BLAST SHOP 1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 8CE interior Corner Assembly, Bottom Panel, Floor Beam and Longitudinal Diaphragms surfaces from the panel point 70 to 71 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
